

Work Order ID 160297

Tuesday, April 25, 2017 1:25:51 PM

160297

Page 1

Item ID: D206-802-027 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Passenger Door Opener LH
Start Date: 4/28/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 5/5/2017 Req'd Qty: 1.00 *1* Customer:
Reference: SCHJEDULED

Approvals: Process Plan: DAS 21 Date: APR 25 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-2	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL	<u>APR 25 2017</u>				<u>DAS 27</u>			
DC	Memo	0.00				<u>9-89</u>			
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-027 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.03				<u>DAS 27</u>			
Quality Control						<u>9-89</u>			

APR 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-027								
	Location: _____								
	PPP rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.10							
Quality Control									

fs 021

sep

DAS 27 9-89 APR 27 2017

DAS 21 9-89 APR 28 2017

DAS 21 9-89 APR 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, April 25, 2017 1:25:54 PM

Page 1

Work Order ID: 160297

160297

Parent Item: D206-802-027

D206-802-027

Parent Item Name: Passenger Door Opener LH

Start Date: 4/28/2017

Required Date: 5/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-17 Door Prop		Manufactured	No			105	Each	2.0000	1	1		APR 26 2017	DAS 26 9-89
D3552-17													
				<u>Location</u>				<u>Loc Qty</u>					
				ST353				2					
				148200				2					
D3622-5 Ball Stud		Manufactured	No			105	Each	14.0000	2	2		APR 26 2017	DAS 26 9-89
D3622-5													
				<u>Location</u>				<u>Loc Qty</u>					
				ST043				14					
				151850				14					
D4110-1 Door Doubler, LH		Manufactured	No			105	Each	4.0000	1	1		APR 26 2017	DAS 26 9-89
D4110-1													
				<u>Location</u>				<u>Loc Qty</u>					
				ST083				4					
				86147				4					
D4112-1 Aft Sill Doubler		Manufactured	No			105	Each	2.0000	1	1		APR 26 2017	DAS 26 9-89
D4112-1													
				<u>Location</u>				<u>Loc Qty</u>					
				ST084				2					
				151820				1					
				151855				1					

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Tuesday, April 25, 2017 1:25:54 PM

Page 2

Work Order ID: 160297

160297

Parent Item: D206-802-027

D206-802-027

Parent Item Name: Passenger Door Opener LH

Start Date: 4/28/2017

Required Date: 5/5/2017

Start Qty: 1.00

Required Qty: 1.00

CR3242-4-2

Purchased

No

105

Each

101.0000

5

5

CR3242-4-2

RIVET

**

APR 26 2017

Location

Loc Qty

Loc Code

CCK003

100

m137061

100

ST318

1

m134962

1

MS20426AD4-5

Purchased

No

105

Each

862.0000

4

4

MS20426AD4-5

RIVET

**

APR 26 2017

Location

Loc Qty

Loc Code

GA

799

m133751

799

ST311

63

m133751

63

MS20600-AD4W2

Purchased

No

105

Each

329.0000

5

5

MS20600-AD4W2

Rivet

**

APR 26 2017

Location

Loc Qty

Loc Code

CCK004

125

m137075

125

CCK005

120

m136579

120

GA

44

m126475

6

m136047

38

ST308

40

m134762

40

Tuesday, April 25, 2017 1:25:54 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Tuesday, April 25, 2017 1:25:54 PM

Page 3

Work Order ID: 160297

160297

Parent Item: D206-802-027

D206-802-027

Parent Item Name: Passenger Door Opener LH

Start Date: 4/28/2017

Required Date: 5/5/2017

Start Qty: 1.00

Required Qty: 1.00

MS21073L5 Purchased No

105 Each 11.0000 2 2

MS21073L5

**

Anchor Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

ST298

11

m135058

11

NAS1149C0532R Purchased No

105 Each 243.0000 6 6

NAS1149C0532R

**

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

84

m135390

8

m136983

76

GA

42

116513

42

ST266

117

m136192

117

NAS1149C0563R Purchased No

105 Each 190.0000 6 6

NAS1149C0563R

**

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST265

190

m131697

190

Tuesday, April 25, 2017 1:25:54 PM

Shop Packet Print

Page 3

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Work Order ID 160297

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160297

Page 1

Item ID: D206-802-027

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Passenger Door Opener LH

Start Date: 4/28/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/5/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHJEDULED

Approvals:

Process Plan:

Date: **APR 25 2017**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D407-802-2

A

100

Document Control

0.00

100

DOCUMENT CONTROL

APR 25 2017

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-802-027 CHG002

**APR 26 2017**

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.03

Quality Control

5.3 D206-802-027/-028 Passenger Door opener Kits

Qty -027	Qty -028	Part Number	Description
		D206-802-027	PASSENGER DOOR OPENER KIT, LH
		D206-802-028	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4110-1	DOOR DOUBLER, LH
	1	D4110-2	DOOR DOUBLER, RH
1	1	D4112-1	AFT SILL DOUBLER
5	5	CR3242-4-2	RIVET
4	4	MS20426AD4-5	RIVET
5	5	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D206-802-033 Baggage Door Opener Kit, Metal

Qty -033	Part Number	Description
	D206-802-033	BAGGAGE DOOR OPENER KIT, METAL
1	D3552-19	DOOR PROP
1	D4109-043	DOUBLER ASSEMBLY
1	D4113-041	DOUBLER ASSEMBLY, BAGGAGE DOOR
4	80-004-2-6	INSERT
8	CR3213-4-2	RIVET
4	MS27039C1-06	SCREW
4	NAS1149C0363R	WASHER